

# Work Order ID 70861

Thursday, June 16, 2011 2:39:16 PM

46



Page 1

Item ID: D3807-5

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:                      Date: 11-06-16 Tooling:                      Date:                       
QC:                      Date:                      SPC (Y/N):                      Date:                     

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3807	Rev A

100 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3807

Dwg Rev:                     

Prog Rev:                     

2-Deburr if necessary

B11-6-28

(6)

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70861**

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Page 2

Item ID: D3807-5

Accept



Setup Start



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Stop



Item Name: Gasket

Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S ulog/25

(x6)

130

Identify as per dwg & Stock Location: FP

0.00



Packaging

Memo

0.00

Packaging

11/7/4 SP C60 SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/4 SP  
CQ 11107104

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# Picklist Print

Thursday, June 16, 2011 2:39:23 PM

Page 1

Work Order ID: 70861



Parent Item: D3807-5



Parent Item Name: Gasket


Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-11-28 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063  NEOPRENE SHEET 0.063		Purchased	No			100	sf	466.6800	1.6	10.66667			



811-6-29

Location

Loc Qty

Loc Code

MAT052

466.68

117295

66.68

118026

400

117295

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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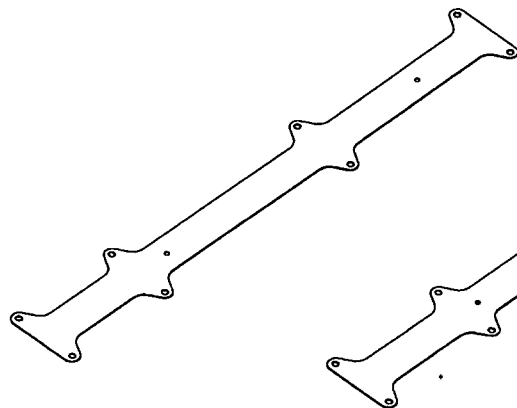
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

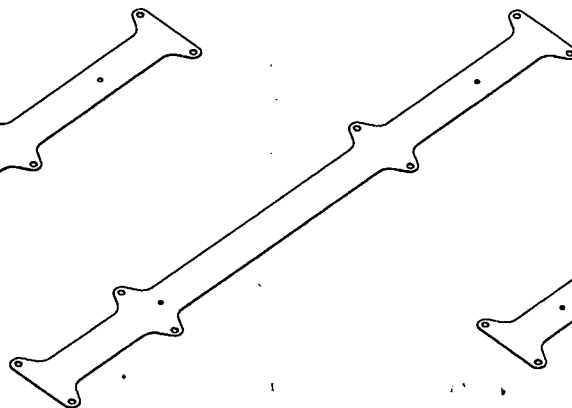
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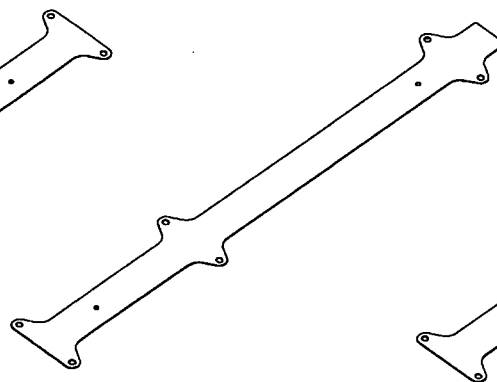




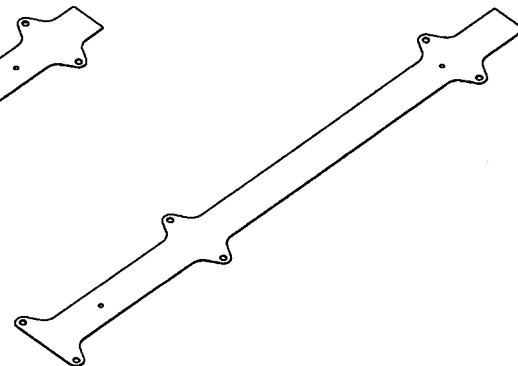
**D3807-1 GASKET**



**D3807-3 GASKET**



**D3807-5 GASKET**



**D3807-7 GASKET**

**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER  
REF. DART SPEC. M-NEO60-S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3807-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:  
D3807-1 = 0.32 lbs  
D3807-3 = 0.36 lbs  
D3807-5 = 0.32 lbs  
D3807-7 = 0.33 lbs

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70861

*11-06-16*

**RELEASED**  
*1093303*  
per ECN 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3807	SHEET 1 OF 3
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	GASKET	NTS
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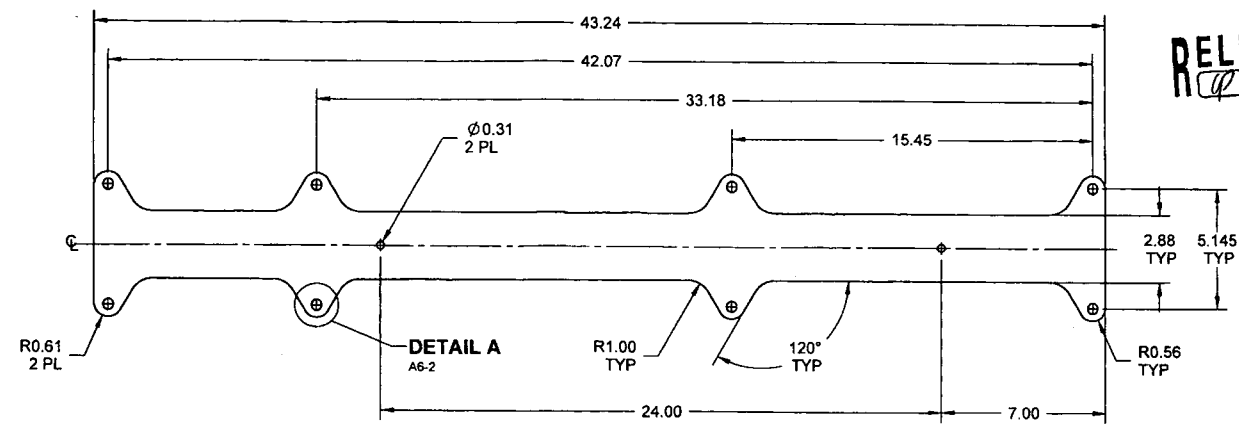
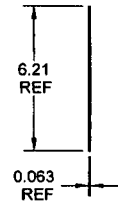
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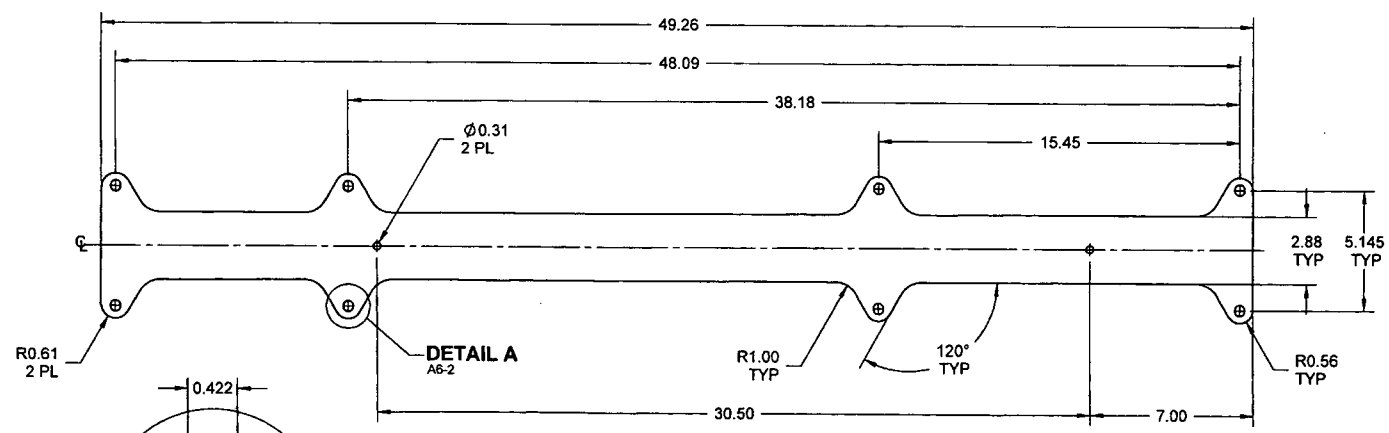
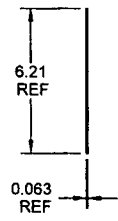
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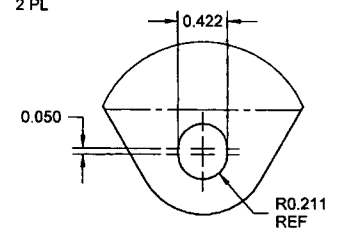
RELEASED  
09.03.07



**D3807-1 GASKET**



**D3807-3 GASKET**



**DETAIL A: SLOT DETAIL**  
TYP  
BS-2  
CS-2  
BS-3  
CS-3

DESIGN	JP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	ALS	DRAWING NO.	REV. A
MFG. APPR.	DS	<b>D3807</b>	SHEET 2 OF 3
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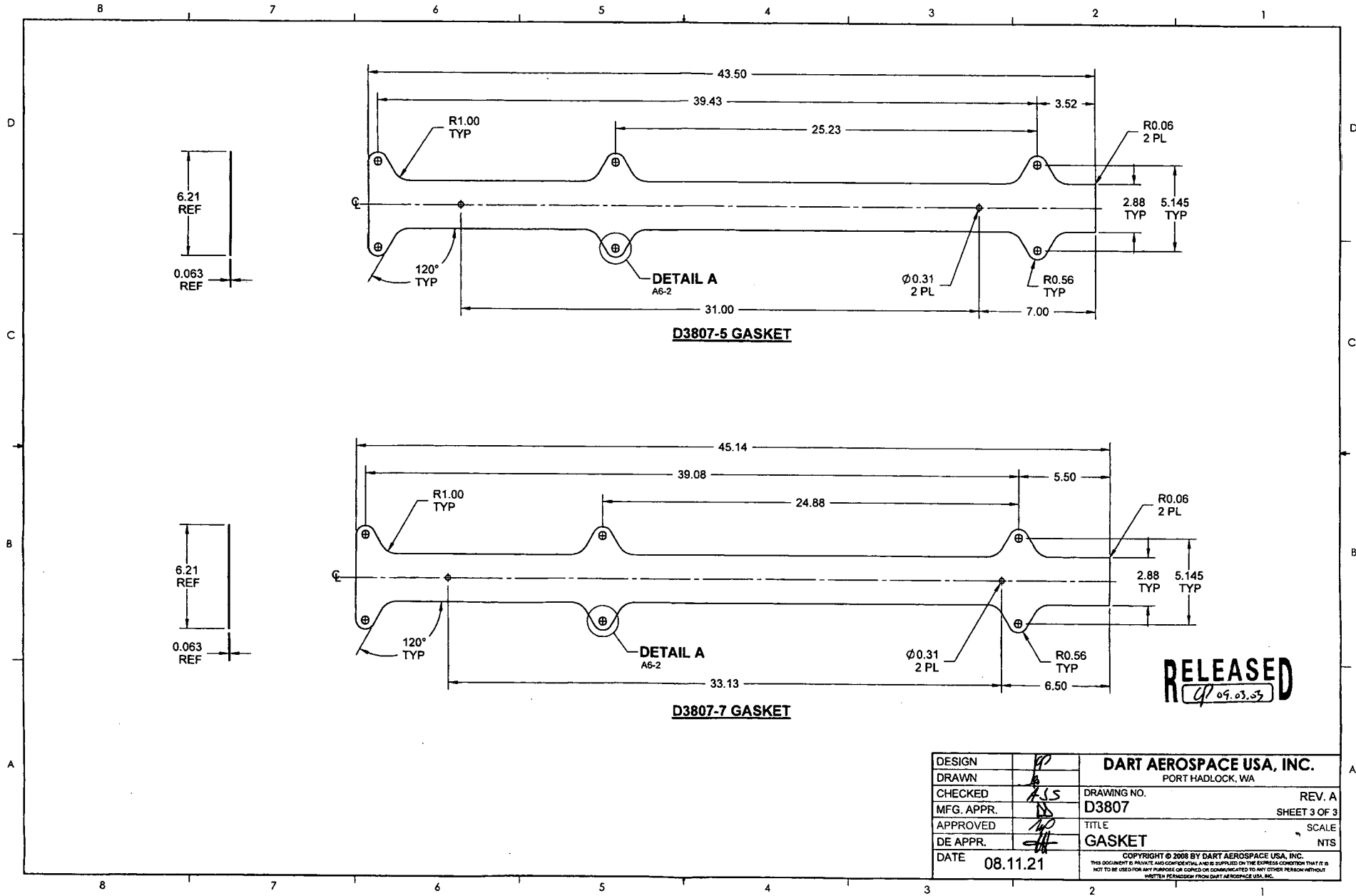
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WLO 10861



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MFG. APPR.	AS	<b>D3807</b>	SHEET 3 OF 3
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